

Work Order ID 134589***134589***

Page 1

Friday, July 10, 2015 10:30:06 AM

Item ID: D206-628-021 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Heli-Access-Step™ LH - High Gear 206L/L1/L3/L4
Start Date: 7/10/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/10/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference: dissassemble

Approvals: Process Plan: MF Date: 15-7 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D206-628	G								

150

0.00

150

Packaging

Memo

0.00

Packaging

PULL FROM STOCK D206-628-021 X 1 B124316

DISSASSEMBLE AND RETURN TO STOCK UNDER ORIGINAL BATCH
NUMBER

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MF
15-7-10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

Friday, July 10, 2015 10:30:04 AM

Page 1

Work Order ID: 134589

134589

Parent Item: D206-628-021

D206-628-021

Parent Item Name: Heli-Access-Step™ LH - High Gear 206L/L1/L3/L4

Start Date: 7/10/2015

Required Date: 7/10/2015

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:D as per ECN 766 JLM

IPP Rev:E as per ecn 1118 DD verified by:EC

IPP Rev:F

11.09.15 added NAS1149D0463J DD verf by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-14A		Purchased					Each	390.0000		-4			
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AN4-14A

Bolt

Location

Loc Qty

Loc Code

FG

5

122141

5

ST325A

304

M128769

4

M132640

200

M132677

100

ST344

81

M132317

81

AN4-15A		Purchased					Each	339.0000		-8			
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AN4-15A

Bolt

Location

Loc Qty

Loc Code

GA

40

120449

40

ST325A

299

m128978

8

m132317

91

m132551

200

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Friday, July 10, 2015 10:30:05 AM

Page 2

Work Order ID: 134589

134589

Parent Item: D206-628-021

D206-628-021

Parent Item Name: Heli-Access-Step™ LH - High Gear 206L/L1/L3/L4

Start Date: 7/10/2015

Required Date: 7/10/2015

Start Qty: 1.00

Required Qty: 1.00

D206-628-021

Manufactured No

Each

1.0000

1

D206-628-021

Heli-Access-Step™ LH - High Gear 206L/L1/L3/L4

Location

Loc Qty

Loc Code

FG081

1

124316

1

Each

1.0000

-1

MF 5-7-10

D2724-041

Manufactured No

D2724-041

206L Step Assembly, LH

Location

Loc Qty

Loc Code

FG

1

123305

1

Each

42.0000

-4

MF 5-7-10

D2731-7

Manufactured No

D2731-7

Mounting Lug

Location

Loc Qty

Loc Code

ST520

42

132234

18

132444

24

Each

121.0000

-8

97497x2

104219x2

DAS
6
8-08

D2732-030

Manufactured No

D2732-030

Rubber Cushion - 3"

Location

Loc Qty

Loc Code

FG

8

107346

2

117118

12

124849

9

132003

4

ST410

86

133074

86

MF 5-8-10

Friday, July 10, 2015 10:30:05 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Past Expiry Date ☐	Manufacturing Process ☐																								
Misidentified ☐	Past Due ☐	OTHER : _____																							

Picklist Print

Friday, July 10, 2015 10:30:05 AM

Page 3

Work Order ID: 134589

134589

Parent Item: D206-628-021

D206-628-021

Parent Item Name: Heli-Access-Step™ LH - High Gear 206L/L1/L3/L4

Start Date: 7/10/2015

Required Date: 7/10/2015

Start Qty: 1.00

Required Qty: 1.00

D3394-043

Manufactured No

Each

45.0000

-4

D3394-043

103484 x 4

DAS

Lug

6

9-89

Location

Loc Qty

Loc Code

ST528

45

131774

16

132499

29

89729

0

MS21042L4

Purchased No

Each

3,960.000

-12

MS21042L 4

Locknut

Location

Loc Qty

Loc Code

FP001

2

m124231

2

GA

150

m127813

150

ST260a

3620

m129472

12

m130799

56

m131803

6

m132262

546

m132382

3000

ST305

188

m128300

16

m130388

7

m130922

97

m131618

12

m132123

56

MF 15-7-10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

Friday, July 10, 2015 10:30:05 AM

Page 4

Work Order ID: 134589

134589

Parent Item: D206-628-021

D206-628-021

Parent Item Name: Heli-Access-Step™ LH - High Gear 206L/L1/L3/L4

Start Date: 7/10/2015

Required Date: 7/10/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

Each

4,285.000

-12

NAS1149D0463.J

WASHER

Location

Loc Qty

Loc Code

GA

53

M129390

53

ST260a

1000

M132677

1000

ST269

3232

M128591

16

M129682

86

M130799

371

M132035

2602

M132317

157

MF 15-7-10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

List Lots

Friday, July 10, 2015 10:27:06 AM

Page 1 of 1

Criteria : Item ID: d206-628-021 All Locations All Warehouses All Quantity

Item ID	Warehouse ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	Type Code	Comments
Item Name	Location ID				Lot Code		
D206-628-021	Main Warehouse	124316	7/10/2015	1.0000	QC21	CHG003	
Heli-Access-Step™ LH -	FG081						
High Gear 206L/L1/L3/L4							
Total:				1.0000			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER :					

LOT TRACKING !!

Parent Item ID /	Reason	Lot Qty	Lot Nbr	Lot Trans Date	Avg Cost Amt
AN4-14A	124316	-8	M128769	9/15/2014 10:32:14 AM	\$.22
AN4-15A	124316	-16	m128978	9/15/2014 10:32:14 AM	\$.25
D2724-041	124316	-2	123305	9/17/2014 3:53:42 PM	\$446.53
D2731-7	124316	-2	97497	9/15/2014 10:32:15 AM	\$11.59
D2731-7	124316	-2	78922	9/15/2014 10:32:15 AM	\$11.59
D2731-7	124316	-2	113240	9/15/2014 10:32:15 AM	\$11.59
D2731-7	124316	-2	104219	9/15/2014 10:32:14 AM	\$11.59
D2732-030	124316	-16	117118	9/15/2014 10:32:15 AM	\$.74
D3394-043	124316	-2	89729	9/15/2014 10:32:15 AM	\$14.86
D3394-043	124316	-6	103484	9/15/2014 10:32:15 AM	\$14.86
MS21042L4	124316	-24	m129472	9/15/2014 10:32:15 AM	\$.20
NAS1149D0463J	124316	-24	M129390	9/15/2014 10:32:15 AM	\$.03

DQA: _____ Date: _____



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